

Work Order ID 50351

July 13, 2009 11:35:27 AM



Page 1

Item ID: D3798-042 **BK**

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacepod Floor

Start Date: 7/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: **W**

Date: 09-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-1 □ Dwg Rev: **A** □ Prog Rev: **A** □ 12-
Deburr if necessary

LB 9-7-09

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

template D3798-1T1

LB 9-7-09

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

template D3798-1T1

2) S 021769

042

SC

Work Order ID 50351



Page 2

July 13, 2009 11:35:27 AM

Item ID: D3798-042

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Item Name: Spacepod Floor

Start Date: 7/13/09

Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 09-07-29 (x1) JLF

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

11109091

Memo

0.00

Powder Coating

START TIME:

10:30am

OVEN TEMPERATURE:

11:00am FINISH TIME:

320°F

=> 09-07-30 (x1) JLF

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BL 09-07-30 (1) JLF

Work Order ID 50351

July 13, 2009 11:35:27 AM

Page 3

Item ID: D3798-042

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Start Date: 7/13/09 Start Qty: 1.00

Required Date: 7/15/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

Small Fab

Memo

0.00

0.00

1- install foam as per dwg D3798 using contact cement
batch: 112225 2- trim foam if necessary

2T 09-08-04

(YI)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 5 09/08/04

(XO)

180



Packaging

Packaging

Identify as per dwg & Stock Location: 241B

Memo

0.00

0.00

9/8/11

(XO) 50

(Signature)

Work Order ID 50351

July 13, 2009 11:35:27 AM



Page 4

Item ID: D3798-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacepod Floor

Start Date: 7/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/01 HJ

MF 09-09-01

Picklist Print

July 13, 2009 11:35:26 AM

Work Order ID: 50351

Parent Item: D3798-042RevA

Parent Item Name: Spacepod Floor


Comments:

Start Date: 7/13/09



Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3798-3RevA		Manufactured	No				Each	2.0000	1.0000			
												
Spacepod Floor Foam												

PT 09-08-04

<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>					
Main Warehouse					
ST				2	
46206				2	
M6061T6S.050	Purchased	No		sf	90.4649 9.2300
					

X1

6061-T6 .050 Sheet

<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>					
Main Warehouse					
MAT				90.4648704	
104186				-1.1988103	
110791				89.6636807	
17349				2	

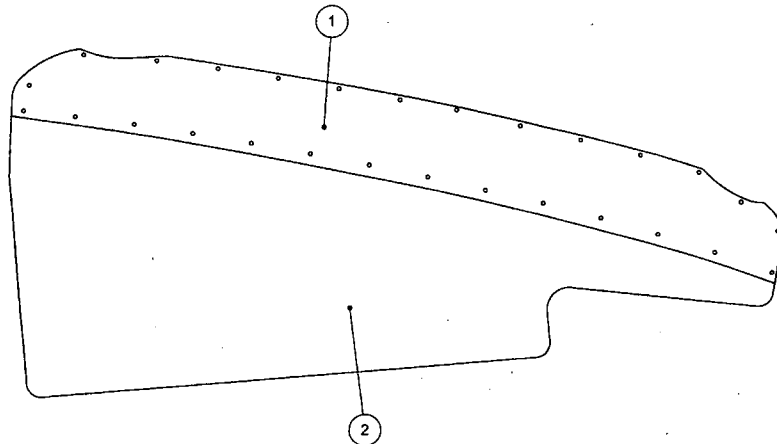
①

110791

13 9-7-09

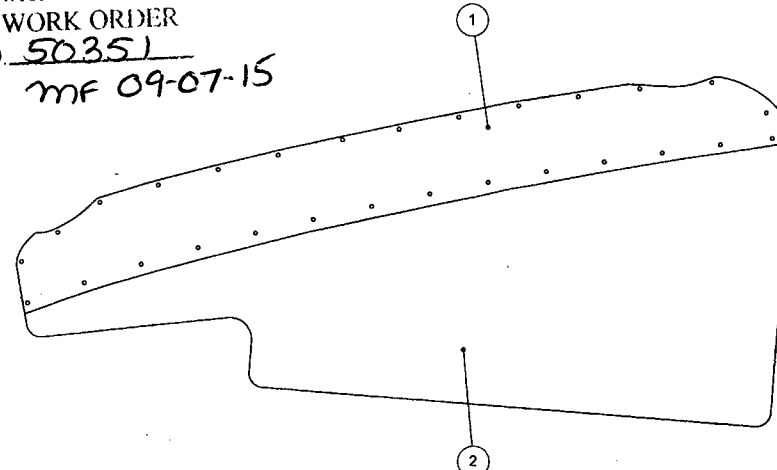
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WORK ORDER
NO. 50351
mf 09-07-15



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

D3798-041 SPACEPOD FLOOR, LH



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

D3798-042 SPACEPOD FLOOR, RH

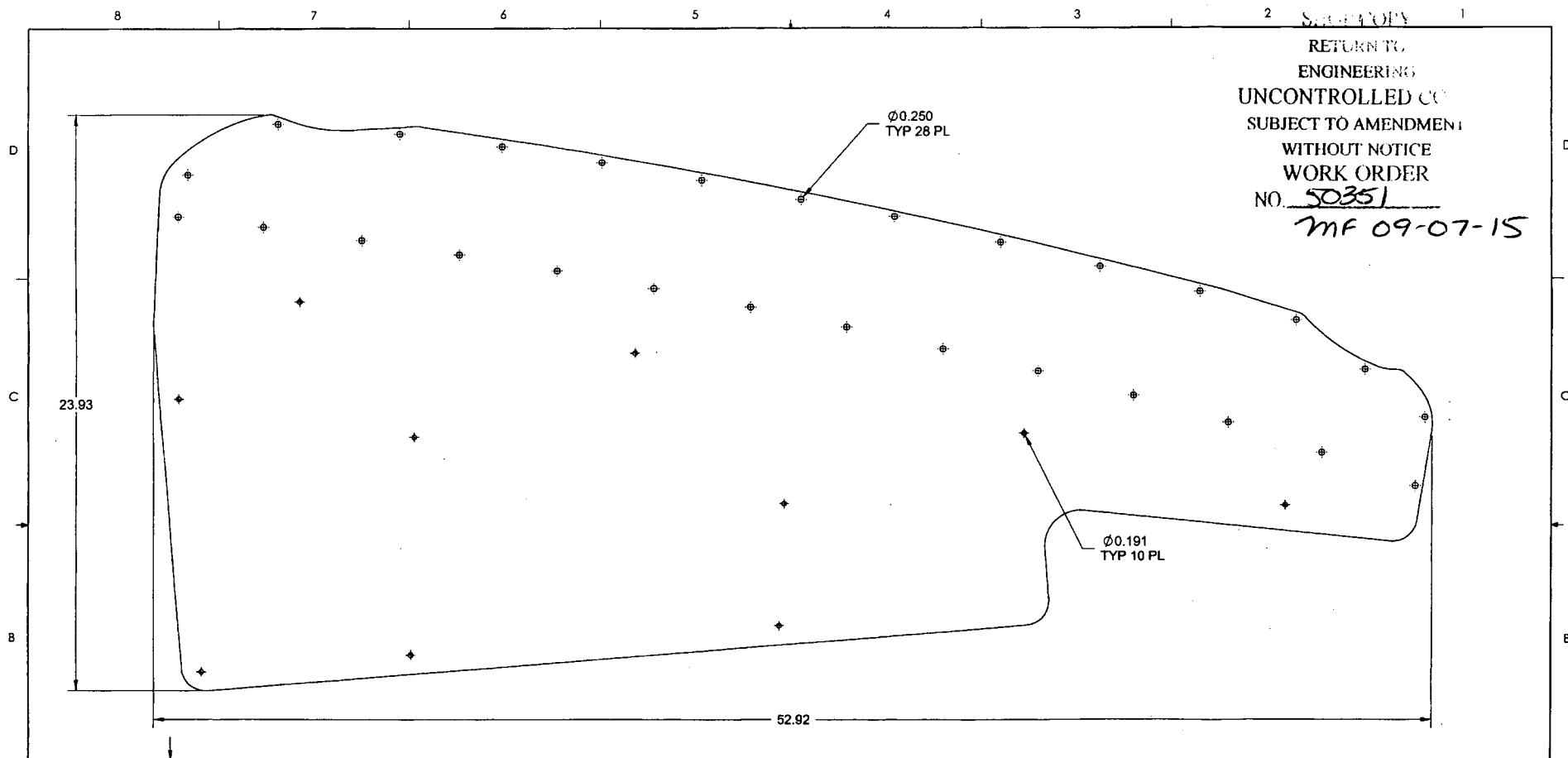
RELEASED
09/01/13 MFD

- NOTES:
1) IDENTIFICATION: IDENTIFY WITH DART P/N D3798-041/-042 USING WHITE FINE POINT PERMANENT INK MARKER
2) WEIGHT: D3798-041 - 4.5 lbs
D3798-042 - 4.5 lbs
3) INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT

A	NEW ISSUE		BY	08.10.20
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.20			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3798	REV. A SHEET 1 OF 3
TITLE SPACEPOD FLOOR	
SCALE NTS	
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


D3798-1 SPACEPOD FLOOR

RELEASED
09/01/13

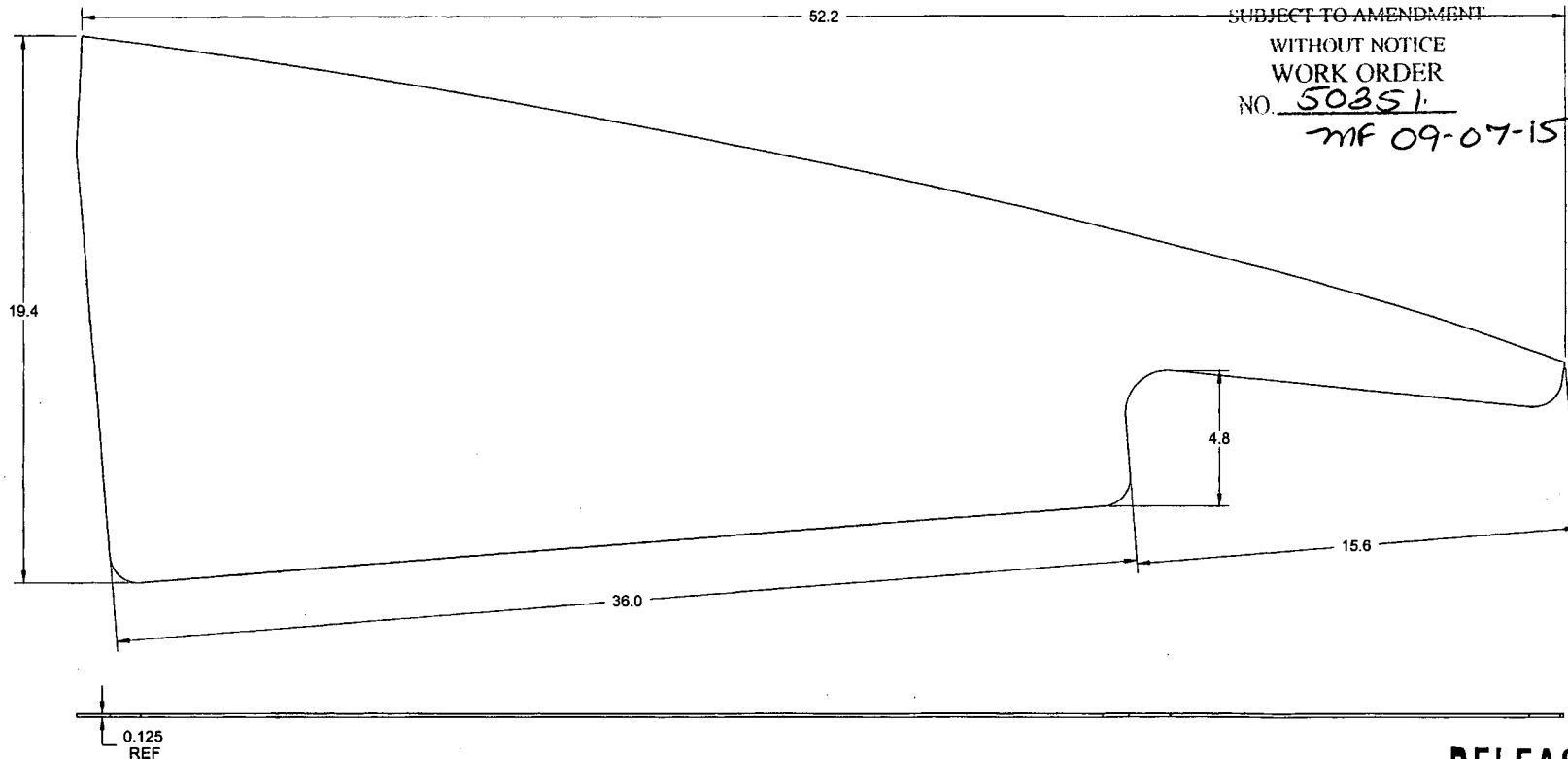
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

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APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
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NO. 50351

MF 09-07-15



D3798-3 SPACEPOD FLOOR FOAM

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK (REF DART SPEC M-4111N-S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.5 lbs
- 8) CONTROL PART PER TEMPLATE DT9433

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